

Work Order ID- 60443

Wednesday, July 07, 2010 3:25:43 PM



SHIP 15 ^{pages} per lot

Item ID: D900-619-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 7/8/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 7/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-7-7

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D900-619

A

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D900-619-011
CHG003

0.00

8/10/29

Refer BG 10/07/29 (3)

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/7/29 (3) 4

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/10/29

(3)

Work Order ID 60443

Wednesday, July 07, 2010 3:25:43 PM

Page 2

Item ID: D900-619-011

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 7/8/2010 Start Qty: 4.00

Required Date: 7/15/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D900-619-011

Location: _____

PPP rev: A

0.00

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/7/29 (3)

10/07/29

10-7-29 (3)

Picklist Print

Wednesday, July 07, 2010 3:25:42 PM

Page 1

Work Order ID: 60443

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 7/8/2010

Required Date: 7/15/2010

Start Qty: 4.00 3

Required Qty: 4.00

Comments: IPP C04.02.17 Blank size changed on Step 3 KJ/JLM
IPP Rev:D Was k10010 07-01-03 JLM
IPP Rev:E New Manufacturing Method 08-11-04 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-15A Bolt		Purchased	No			110	Each	387.0000	8	3224		10/7/29	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST358			387						
					114784		87						
					115108		300						
AN960JD416 Washer	NAS1149D0463J	Purchased	No			110	Each	12.0000	8	1224		10/7/29	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351			12						
					108827		12						
D2182B Rubber Cushion		Manufactured	No			110	f	254.3952	2	86		10/7/29	(30)
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST402A			9.67						
					30872		9.67						
				ST410			244.7252						
					52649		244.7252						

(D2182B060) cut 4 at 6.00" as per dwg per kit

→ measure 8/10/29/25

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 07, 2010 3:25:42 PM

Page 2

Work Order ID: 60443

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 7/8/2010

Required Date: 7/15/2010

Start Qty: 4.00 3

Required Qty: 4.00

D2274 Manufactured No 110 Each 357.0000



Radius Block

Location

Loc Qty

Loc Code

ST010

357

57912

137

59108

220

D2421 Manufactured No 110 Each 0.0000



Bearpaw, 900

D2519 Manufactured No 110 Each 36.0000



Clamp

Location

Loc Qty

Loc Code

ST456

36

56763

36

D2529 Manufactured No 110 Each 338.0000



Washer

Location

Loc Qty

Loc Code

ST017

338

58568

338



8

3224

10/7/29

sf



2

186

360444

10/7/29

sf



4

146

10/7/29

sf



8

12

3224

10/7/29

sf

30

24

Wednesday, July 07, 2010 3:25:42 PM

Shop Packet Print

Page 2

Picklist Print

Page 3

Wednesday, July 07, 2010 3:25:42 PM

Work Order ID: 60443

Parent Item: D900-619-011

Parent Item Name: Bearpaw



Start Date: 7/8/2010

Required Date: 7/15/2010

Start Qty: 4.00 3

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

4,394.000

8



Nut

Location

Loc Qty

Loc Code

ST300	4382
113422	68
114523	28
114718	286
114784	2000
115108	2000

ST356

12

108145

12

QS100-M24S

Purchased

No

110

Each

36.0000

4



Clamp

Location

Loc Qty

Loc Code

ST449	36
114619	26
114885	10

32 27
10/7/292f

27

4612
10/7/292f

(30)

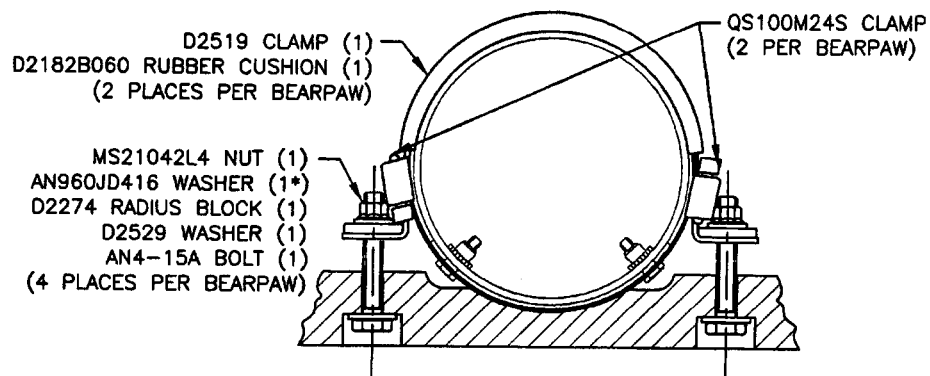
2
10

Wednesday, July 07, 2010 3:25:42 PM

Shop Packet Print

Page 3

REFERENCE ON



* See note 6

Figure 32-2: Bearpaw Installation (section view)

6. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
7. Lower the aircraft

32.2 BEARPAW REMOVAL

1. Jack up the aircraft.
2. Loosen the clamp bolts and remove the bearpaws and clamps. Ensure the skid tubes are serviceable.
3. Lower the aircraft.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D900-619-011 Bearpaw Installation	13.8 lb 6.3 kg	0.0 in 0.0 m	0.0 lb-kp 0.0 m-kp	233.3 in 5.93 m	3220 in-lb 37.4 m-kp

32.4 PARTS LIST

Qty	Part Number	Description
X	D900-619-011	BEARPAW INSTALLATION
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D2421	BEARPAW
4	D2519	CLAMP
8	D2529	WASHER
8	AN4-15A	BOLT
8	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP

• COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

32-00-00

Revision: 0

Page 3 (4 blank) of 4